

Work Order ID 56984

Tuesday, March 16, 2010 10:28:42 AM



Page 1

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 3/16/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 3/23/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-3-16

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: 1109213 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

② PD 10-03-18

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

② PD 10-03-18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 56984

Tuesday, March 16, 2010 10:28:42 AM

Page 2

Item ID: D4035-041

Accept

Revision ID:

Item Name: Lid Rib Assembly, Fwd (350 Basket)




Start Date: 3/16/2010 Start Qty: 1.00

Required Date: 3/23/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120  QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | Swolsky | | | ⓧ | | | |
| 130  Packaging Packaging | Identify as per dwg & Stock Location: <u>WA10</u> Memo | 0.00 0.00 | Swolsky | | | ⓧ | | | |
| 140  QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

Lpl 10-03-23

10/03/24
MF
10-3-23

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 16, 2010 10:28:42 AM

Page 1

Work Order ID: 56984

Parent Item: D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Date: 3/16/2010

Required Date: 3/23/2010

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2327-3 | | Manufactured | No | | | 100 | Each | 37.0000 | 1.0000 | | | |



Spacer Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 13

44274 4

44365 9

Main Warehouse

WA 24

55167 4

55917 20

M304TS0.750W.049

Purchased

No

100

f

170.5455

1.8421



304 SQ Tube .75x.75x.049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 170.5455158

106604 2.4123

107460 28.2726

113763 139.860616

Q

QPL 10.03.18

QPL

Q

QPL 10.03.18

QPL

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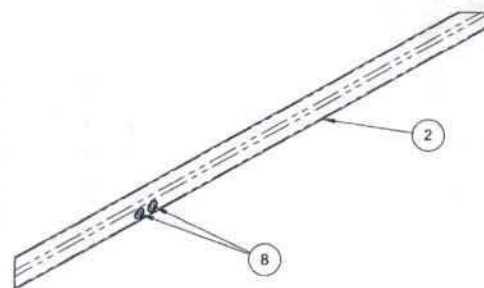
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

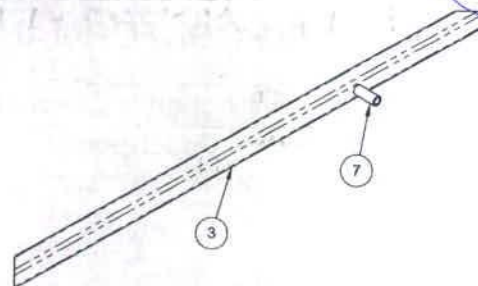
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NOTE: Date & initial all entries

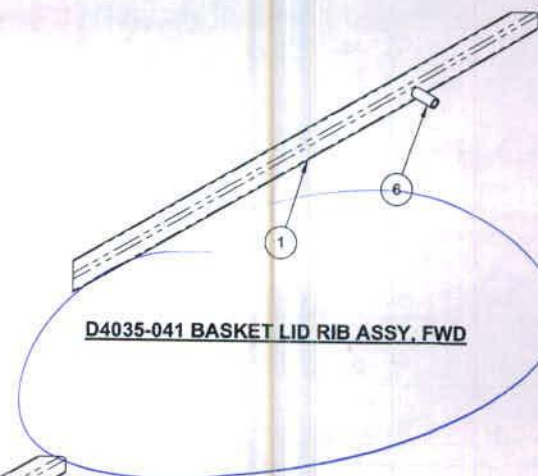
| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-----------|---------------------------|
| | X | | | | D4035-041 | LID RIB ASSY, FWD |
| | | X | | | D4035-043 | LID RIB ASSY, AFT |
| | | | X | | D4035-045 | LID RIB ASSY, FWD (LIGHT) |
| | | | | X | D4035-047 | LID RIB ASSY, AFT (LIGHT) |
| 1 | 1 | | | | D4035-1 | RIB |
| 2 | | 1 | | | D4035-3 | RIB |
| 3 | | | 1 | | D4035-5 | RIB |
| 4 | | | | 1 | D4035-7 | RIB |
| 5 | | | | 2 | D4035-11 | BUSHING |
| 6 | 1 | | | | D2327-3 | SPACER BUSHING |
| 7 | | | 1 | | D2953-175 | SPACER |
| 8 | | 2 | | | D4021-9 | BUSHING |



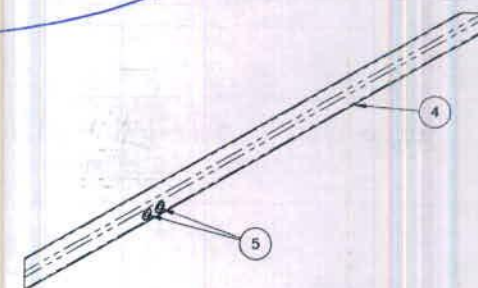
D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-041 BASKET LID RIB ASSY, FWD



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

56984

RELEASED
2010-03-12

| | | | | | |
|------------|-------------|---|--|------------------------|----------|
| A | | NEW ISSUE | | JPH | 10.03.04 |
| REV. | DESCRIPTION | | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. A SHEET 1 OF 5 | |
| DRAWN | JPH | | | | |
| CHECKED | | DRAWING NO. D4035 | | SCALE | |
| MFG. APPR. | | TITLE BASKET LID RIB ASSY | | NTS | |
| APPROVED | | DATE 10.03.04 | | | |
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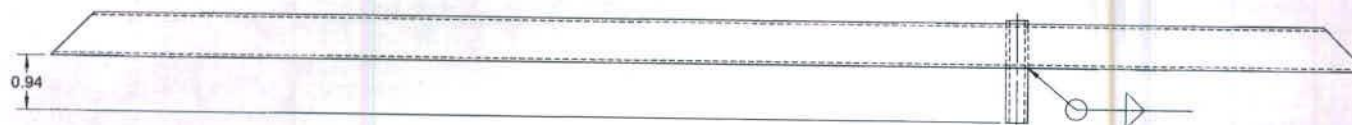
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY, AFT

56984

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JFH | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4035 | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID RIB ASSY | NTS |
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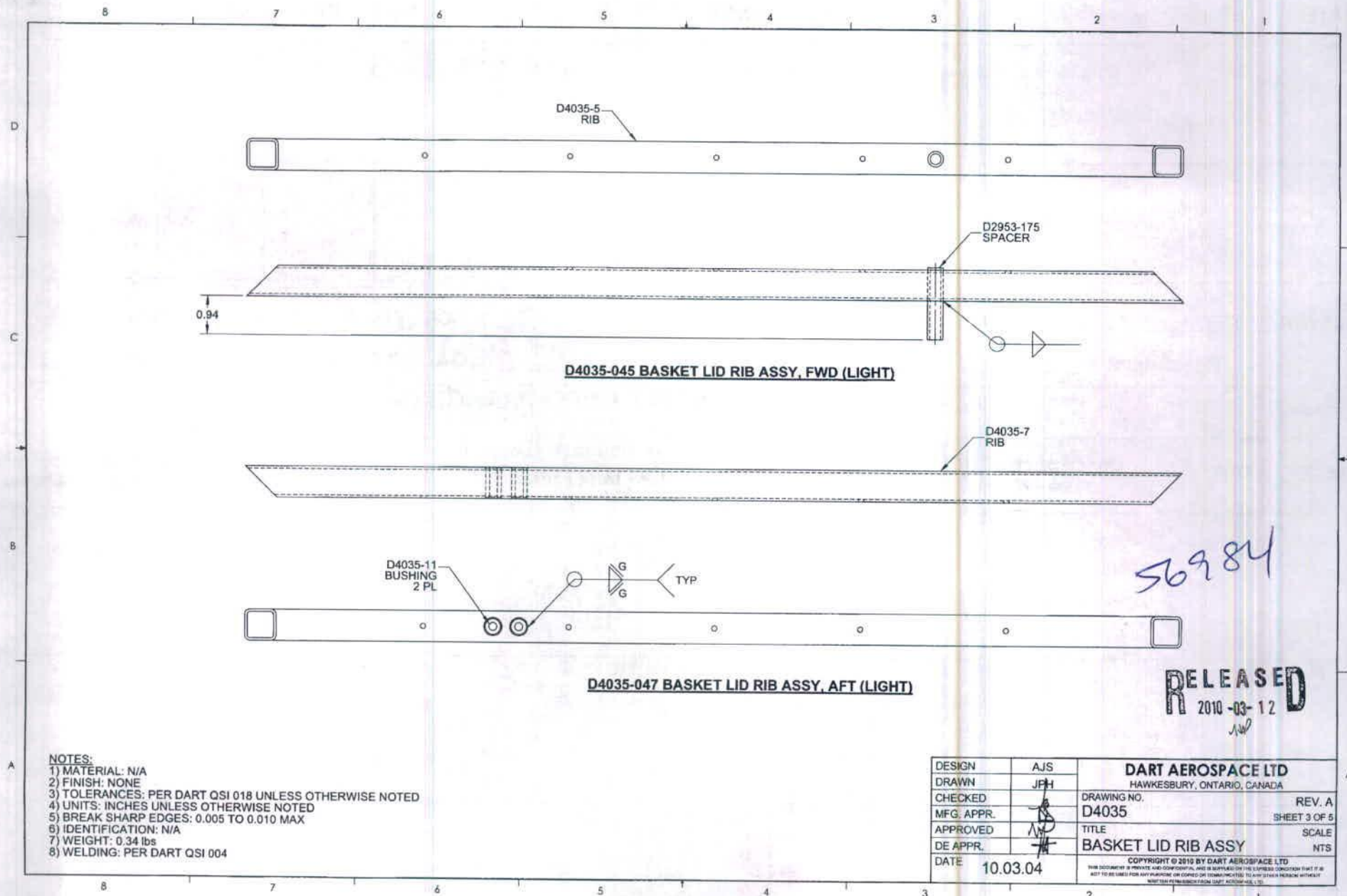
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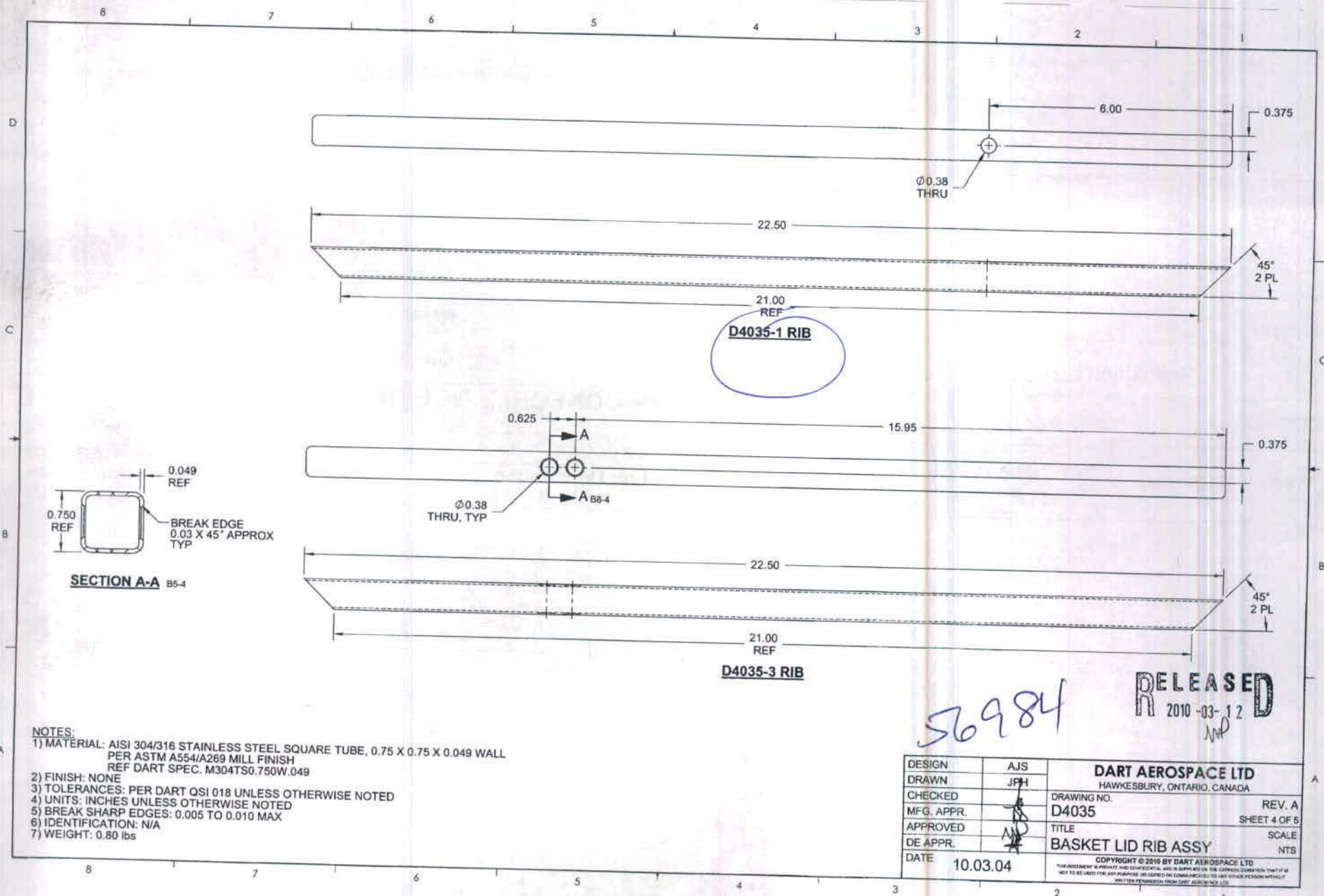
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NOTE: Date & initial all entries



SECTION A-A B5-4

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.80 lbs

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2010-03-12

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| DESIGN | | AJS | |
| DRAWN | | JPH | |
| CHECKED | | DRAWING NO. | D4035 |
| MFG. APPR. | | TITLE | BASKET LID RIB ASSY |
| APPROVED | | SCALE | NTS |
| DE APPR. | | DATE 10.03.04 | |

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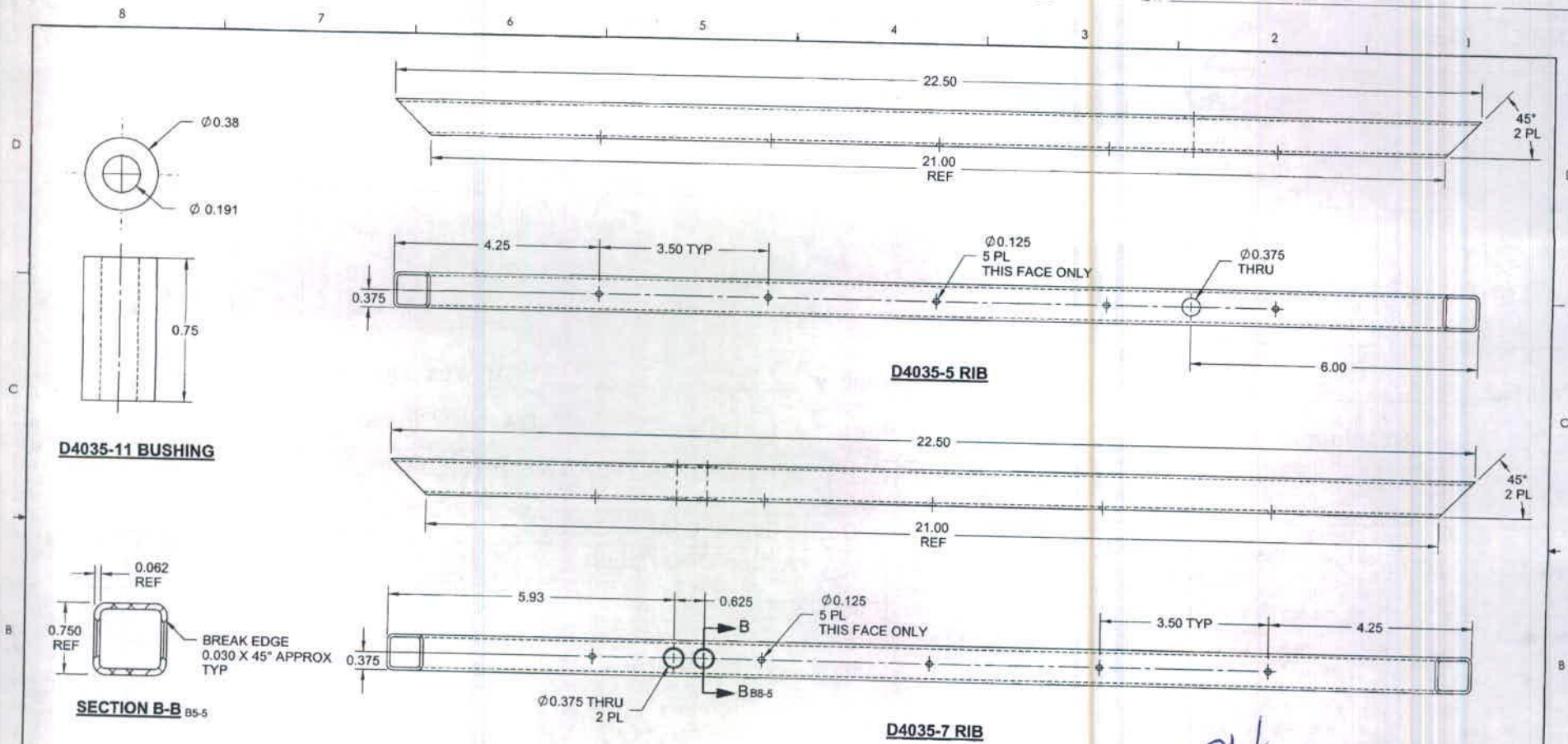
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NOTE: Date & initial all entries



- NOTES:
- 1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
-11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4035 | SHEET 5 OF 5 |
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2010-03-12
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